

Work Order ID 101991

\*101991\*

Page 1

May-22-13 10:57:05 AM

Item ID: D4773-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 5/22/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4773

A

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dyg

prog rev: A

dwg rev: A

304 .050

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

6

2

0

Jm 3-5-22

2

0

Jm 3-5-22

# Work Order ID 101991

May-22-13 10:57:05 AM

\*101991\*

Page 2

Item ID: D4773-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 5/22/13

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

DAS  
21

\*120\*

0.00

KS 23

QC

Memo

Quality Control

130

0.00

\*130\*

0.00

Small Fab

Memo

Small Fab

Form as per dwg D4773

13 S 27

140

QC5- Inspect part completeness to step on W/O

0.00

DAS  
21

\*140\*

0.00

QC

Memo

Quality Control

SB  
13/05/27

**Work Order ID 101991****\*101991\***

Page 3

May-22-13 10:57:05 AM

Item ID: D4773-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 5/22/13

Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: W/A 001

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

202/3-5-28

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

13/5/29MF  
13-5-29

# Picklist Print

May-22-13 10:57:05 AM

Page 1

Work Order ID: 101991

Parent Item: D4773-1

Parent Item Name: Wearplate

Start Date: 5/22/13

Required Date: 5/24/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA  
304/316 .050 Sheet

Purchased

No

100

sf

351.1699

1.31

2.7578947

2.8

Jm35-22

Location

Loc Qty

Loc Code

MAT019

256.8

117188

5

117766

5

120604

5

122325

3

123155

3

124572

153.8

125552

82

125552

MAT020

94.369894

120243

2

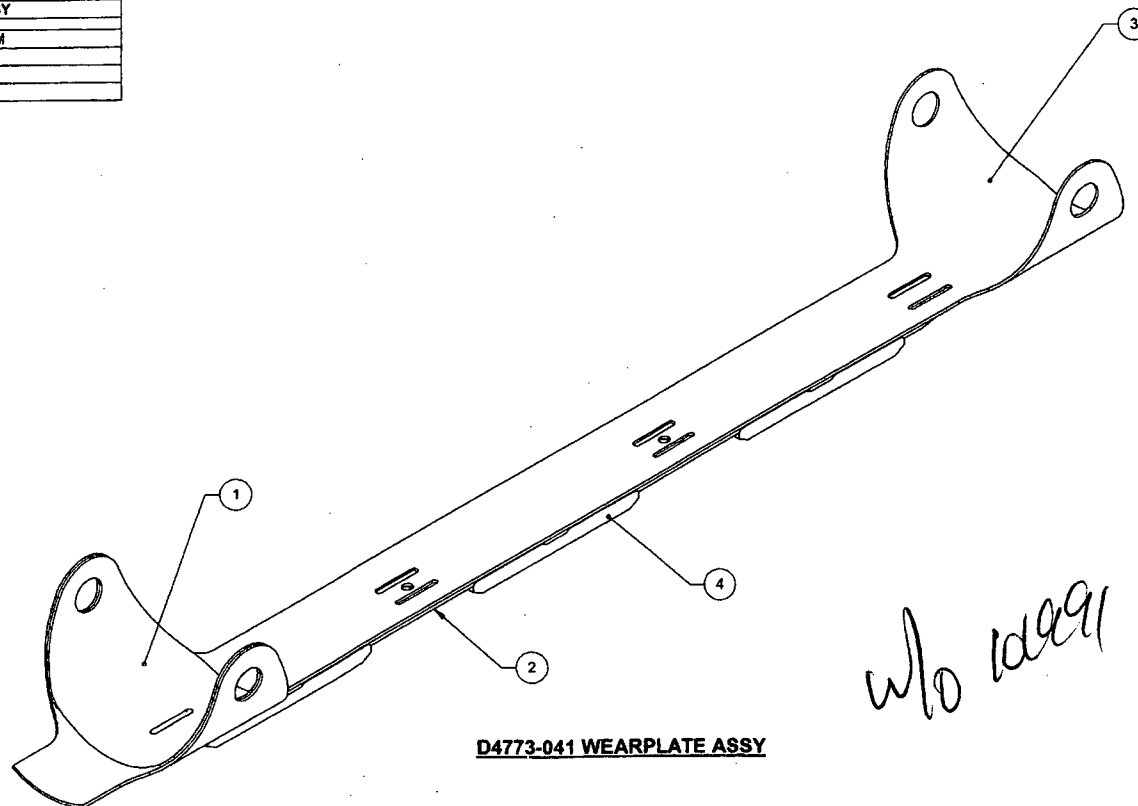
121626

1.529894

124029

90.84

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4773-041	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE SHIM
2	2	D4770-1	BAR
3	1	D4773-1	WEARPLATE
4	A/R	2059B	HARDCOAT



**D4773-041 WEARPLATE ASSY**

*w/o 10091*

RELEASED  
2013-03-25

A		NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.			
DRAWN	AP	KENT, WA			
CHECKED	RP	DRAWING NO.	D4773	REV. A	
MFG. APPR.				SHEET 1 OF 3	
APPROVED		TITLE	WEARPLATE ASSY	SCALE	
DE APPR.				NTS	
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

8 7 6 5 4 3 2 1

D

C

B

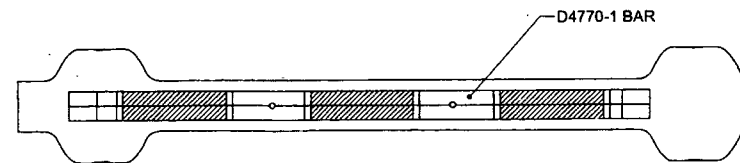
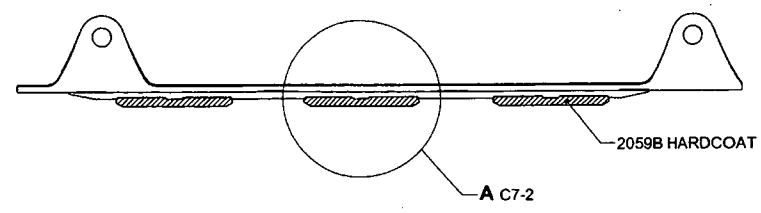
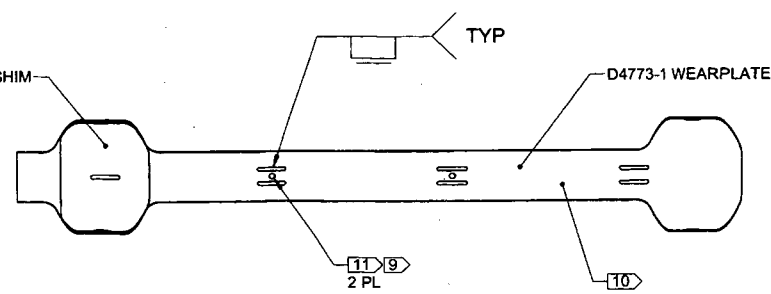
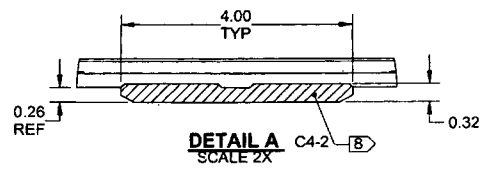
A

D

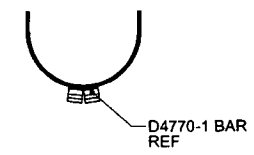
C

B

A



**D4773-041 WEARPLATE ASSY**



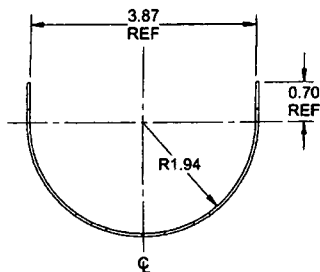
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4773-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.91 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL  $\phi 0.188$  HOLE FROM D4773-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO  $\phi 0.188$  AFTER APPLYING PLUS ONE ROCKGUARD

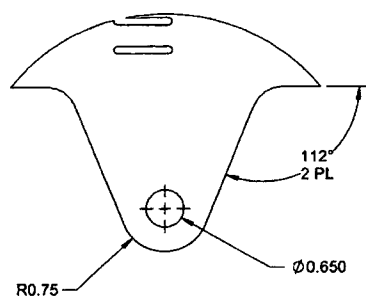
DESIGN	DB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AP	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4773	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

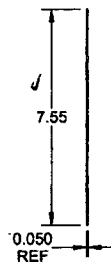
RELEASED  
2013-03-23



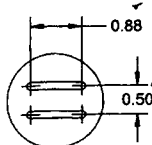
**SECTION D-D** D4-3 **B**  
SCALE 2X



**DETAIL C** B4-3  
4 PL  
SCALE 2X



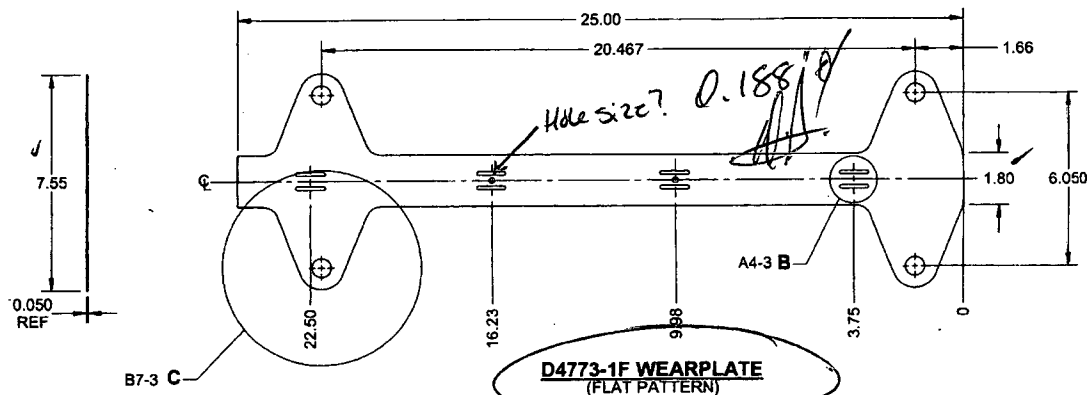
B7-3 C



**DETAIL B** B2-3  
4 PL  
SCALE 2X



**D4773-1 WEARPLATE**  
(MAKE FROM D4773-1F)



**D4773-1F WEARPLATE**  
(FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4773-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

**RELEASED**  
2013-03-25  
NM

DESIGN	DB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AP	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4773	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE ASSY	NTS
DATE	13.02.13	<small>           COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.         </small>	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	101991
<b>Description:</b> <i>Interplate</i>		<b>Part Number:</b>	04773-1
<b>Inspection Dwg:</b> 04773 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.189"	+0.005" - 0.001"	0.192"	-		V	Jkmd1
Ø 0.650"	+0.008" - 0.001"	0.652"	-		V	
0.88"	+/- 0.030"	0.882"	-		V	
0.50"	+/- 0.030"	0.505"	-		V	
1.80	+/- 0.030"	1.80"	-		V	
6.050"	+/- 0.010"	6.052"	-		V	
7.55"	+/- 0.030"	7.561"	-		V	
1.66"	+/- 0.030"	1.66"	-		V	
20.467"	+/- 0.010"	20.467"	-		T	Jkmo6
25.00"	+/- 0.030"	25.00"	-		T	
3.75	+/- 0.030"	3.761"	-		V	
9.98"	+/- 0.030"	9.984"	-		V	Produra
16.23"	+/- 0.030"	16.23"	-		T	
22.50"	+/- 0.030"	22.50"	-		T	
0.050"	+/- 0.010"	0.047"	-		V	

<b>Measured by:</b> <i>Jr</i>	<b>Audited by:</b> <i>27</i>	<b>Preliminary Approval:</b>
<b>Date:</b> <i>13-5-22</i>	<b>Date:</b> <i>13-5-22</i>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*